

Work Order ID 70437

Wednesday, June 08, 2011 9:16:11 AM



Page 1

Ship Friday

Item ID: D3210-1B

Accept



Setup Start



Revision ID: PRELIM

Item Name: Doubler

Stop



Start Date: 6/8/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00



Customer:

PRELIMINARY ISSUE

Reference:

Approvals:

Process Plan: UMFDate: 11-06-08

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3210

PB1

B

11.06.14

0.00



FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3210 ☐ Dwg Rev: PB1 ☐ Prog Rev: PB1 ☐ 2-
Deburr if necessary

2024. OEC

11-6-8

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11-6-8

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

- inspected to PB1

Dwg only

2024.06.08 @

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

Deburr

140



QC

QC5- Inspect part completeness to step on W/O

0.00

w/AS

Quality Control

Memo

0.00

150



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

IX *[Signature]* m-24/06/09

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Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



Powdercoat

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Memo

START TIME:

8:45

0.00

OVEN TEMPERATURE:

9:15

FINISH TIME:

3:20

Powder Coating

170



QC

QC3- Inspect Part Finish

0.00

Memo

0.00

Quality Control

180



Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

Packaging

IX ~~Ø~~ M-1 11/06/04

1 BR 11-6-9.

11/6/14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Page 4

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Start Date: 6/8/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/6/15

PRELIMINARY ISSUEME
11-06-14

POSITIVE RECALL

EFFECTIVE 11/6/08

AUTH

RELEASED

DATE 11/06/14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries

Picklist Print

Wednesday, June 08, 2011 9:16:08 AM

Page 1

Work Order ID: 70437

Parent Item: D3210-1B

Parent Item Name: Doubler



Start Date: 6/8/2011

Required Date: 6/10/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 11.06.07 New issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.080

Purchased

No

sf

112.1000

0.53



11-6-8

2024-T3 .080 sheet

Location

Loc Qty

Loc Code

MAT022

112.1

105411

6

109424

4

110347

0.5

110908

3

112331

3

113796

7

114025

17.2

116604

7.8

117392

63.6

116604

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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D

C

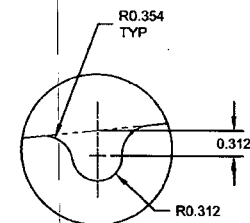
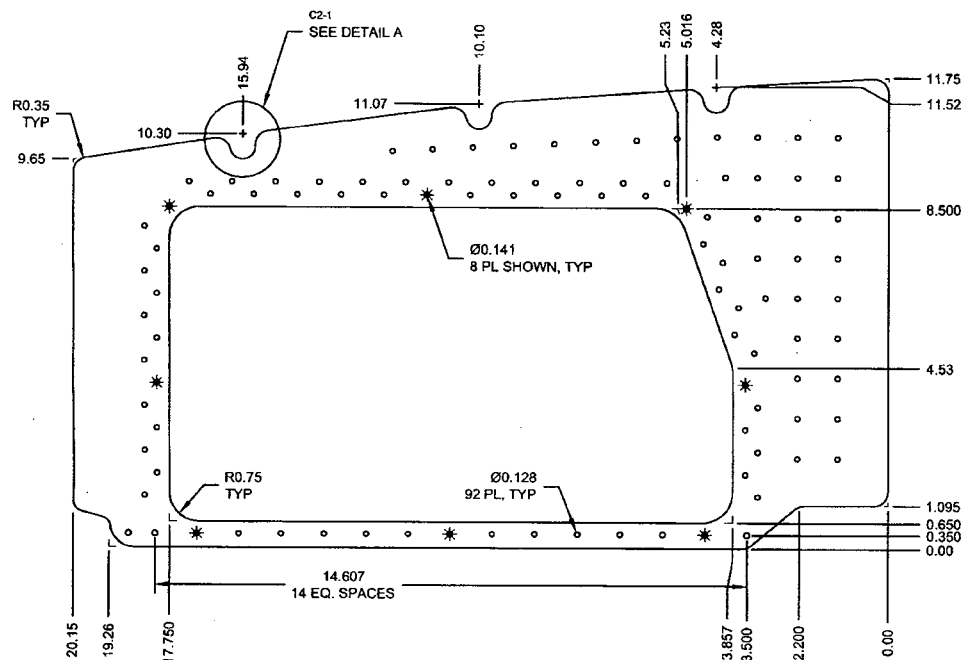
C

B

B

A

A



DETAIL A
SCALE 2X

PRELIMINARY
ISSUE

D3210-1 DOUBLER

D3210-1 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF. DART SPEC M2024T3S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-1" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.86 lbs
- 8) MAKE PER "D3210-1_REVB.DXF"

PB1	FORMAT TO CURRENT STD; ADD D3210-1B. REASON: PAR11-109.		MB	11.06.03
A	NEW ISSUE		CP	03.09..03
REV.	DESCRIPTION		BY	DATE
DESIGN	47	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN			DRAWING NO.	REV. PB1
CHECKED			D3210	SHEET 1 OF 2
MFG. APPR.			TITLE	SCALE
APPROVED			DOUBLER	NTS
DE APPR.				
DATE	11.06.03		COPYRIGHT © 2003 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES						
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NOTE: Date & initial all entries

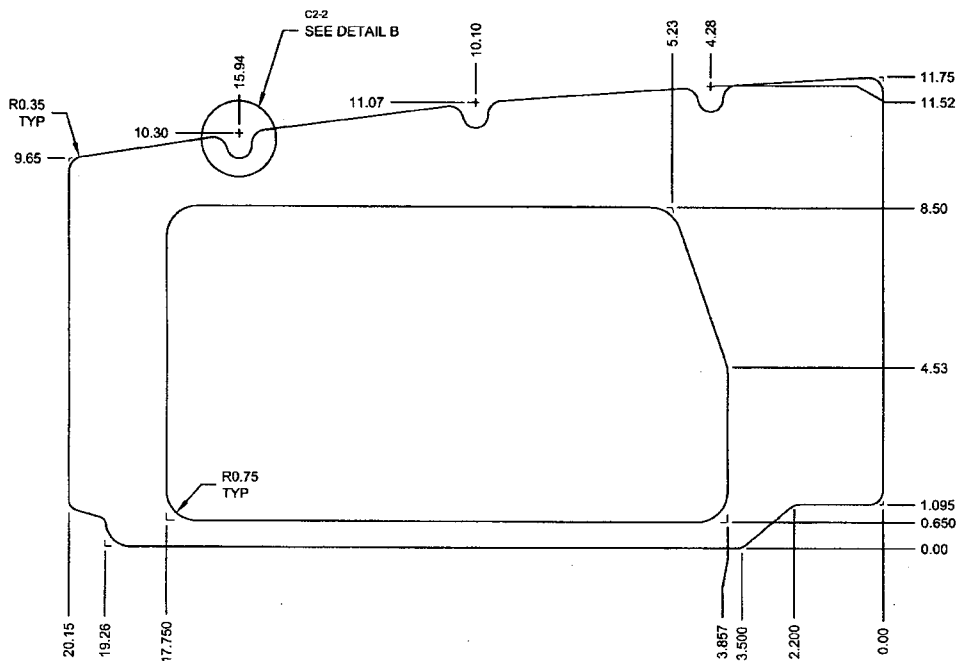
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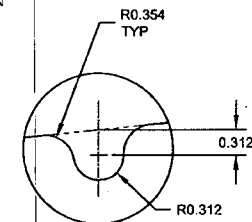


D3210-1B BLANK DOUBLER

D3210-1B NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF. DART SPEC M2024T3S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3298-1B" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.87 lbs
- 8) MAKE PER "D3210-1B_REV.B.DXF"

#70437



DETAIL B
SCALE 2X

**PRELIMINARY
ISSUE** 11.06.07

DESIGN	97	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. PB1
CHECKED		D3210	SHEET 2 OF 2
MFG. APPR.		TITLE	SCALE
APPROVED		DOUBLER	NTS
DE APPR.		COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	11.06.03		

8 7 6 5 4 3 2 1

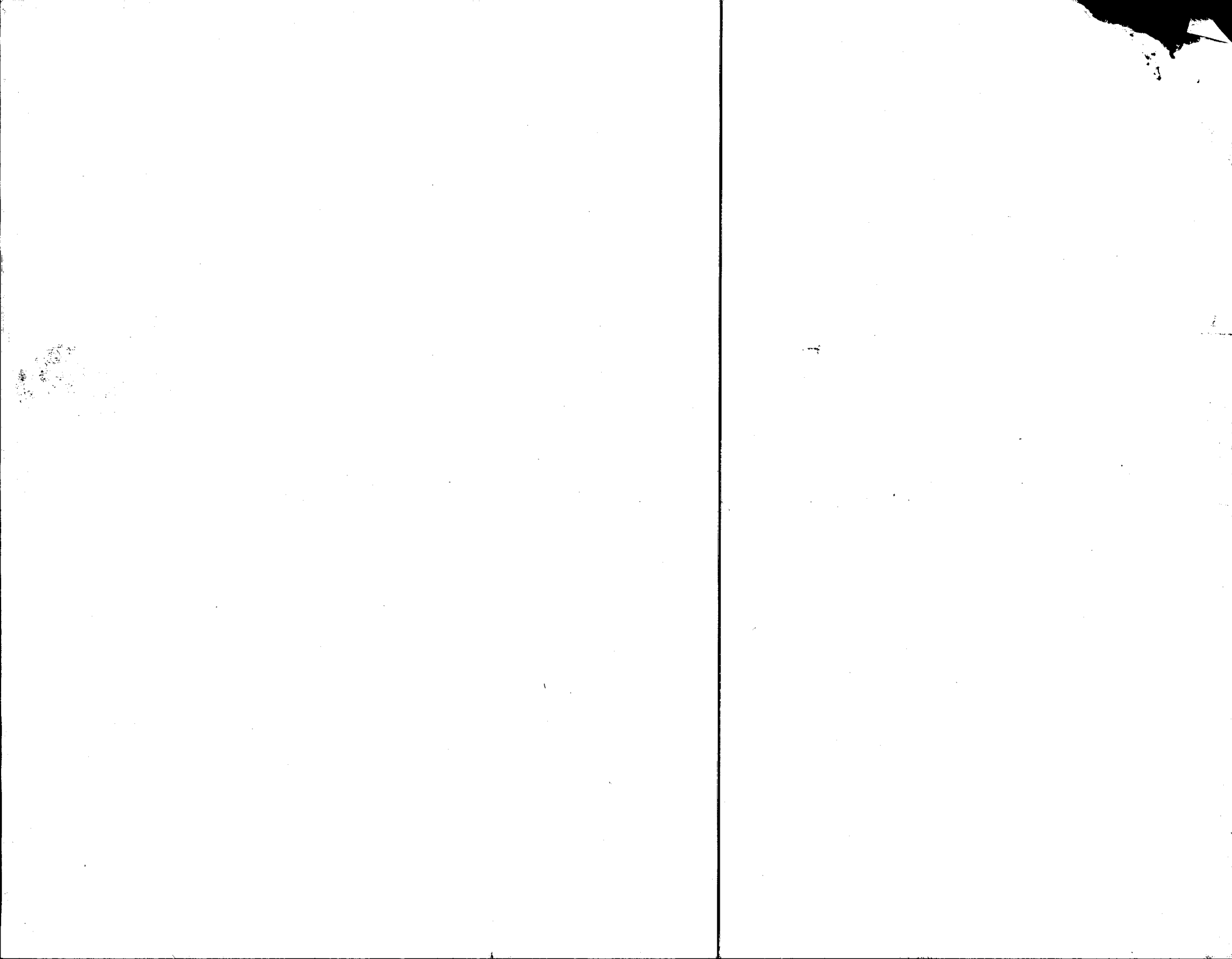
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8 7 6 5 4 3 2 1

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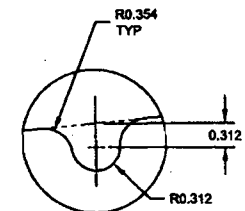
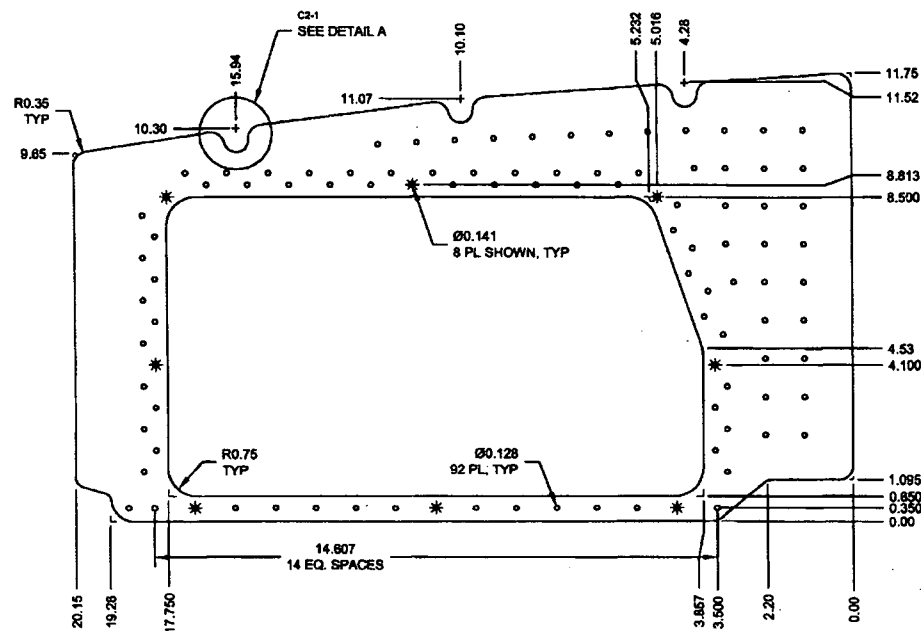
C

B

B

A

A



DETAIL A
SCALE 2X, 3 PL

70437

RELEASED
2011-06-14

D3210-1 DOUBLER

D3210-1 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF. DART SPEC M2024T3S.080
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- 7) WEIGHT: 0.86 lbs
- 8) MAKE PER "D3210-1_REV.B.DXF"

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REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.06.03		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3210
TITLE DOUBLER
REV. B
SHEET 1 OF 2
SCALE NTS

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8 7 6 5 4 3 2 1

